

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (currently amended): A metal member to be cast-wrapped by a metal cast article, wherein said metal member to be cast-wrapped has an extruded ~~irregular upset~~ roughened surface portion defined by surface tears producing a plurality of irregularly formed defining projection projections which extend outwardly from said surface, and wherein a maximum width of said projections at a tip end portion thereof is wider than a maximum width of the projections at a base portion thereof.

Claim 2 (Previously presented): A metal member to be cast-wrapped as claimed in claim 1, wherein at least a part of said tip end portion of each of said projections is formed in a tapering sharp sectional shape.

Claim 3 (Previously presented): A metal member to be cast-wrapped as claimed in claim 1 or 2, wherein said extruded, roughened surface is arranged as elongated mutually spaced surface portions extending parallel to a direction of extruding of the member and wherein elongated smooth, unroughened surface portions are disposed between, and extend parallel to, said roughened surface portions.

Claim 4 (Previously presented): A metal member to be cast-wrapped as claimed in claim 3, wherein a side of each of said irregularly formed projections facing an extrusion starting end is wide and high, and a side of each of said irregularly formed projections facing an extrusion completing end is narrow and low.

Claim 5 (original): A metal member to be cast-wrapped as claimed in claim 1 or 2, wherein said metal member to be cast-wrapped is a hollow cylindrical body.

Claim 6 (Withdrawn): A cylindrical metal member to be cast-wrapped, wherein said cylindrical metal member has an outer surface formed with projections, said projections are arranged axially in rows and arranged circumferentially at regular intervals through grooves, and tip end portions of said projections are bent laterally.

Claim 7 (Withdrawn): A cylindrical metal member to be cast-wrapped, wherein said cylindrical metal member has an outer surface formed with projections, said projections are arranged axially in rows and arranged circumferentially at regular intervals through grooves, and tip end portions of said projections are bent in axial direction.

Claim 8 (Withdrawn): A cylindrical metal member to be cast-wrapped as claimed in claim 6 or 7, wherein said projections are arranged axially at irregular intervals and are not aligned

circumferentially.

Claim 9 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped by a metal cast article having an outer surface with projections; comprising:

preparing a die having an inner peripheral surface formed with longitudinal grooves of depth H and width W, relation between a maximum depth H_{MAX} and a minimum width W_{MIN} of the groove being set as $H_{MAX} / W_{MIN} \geq 1.5$;

inserting a cylindrical metal material in said die; and

hot-extruding said cylindrical metal material to obtain the cylindrical metal member to be cast-wrapped having an outer surface with projections.

Claim 10 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped as claimed in claim 9, wherein said minimum width W_{MIN} of said groove is set as $W_{MIN} \leq 1.3$ mm.

Claim 11 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped as claimed in claim 9 or 10, wherein relation between a minimum inner diameter d and a total inner peripheral length L of a cross-section of said die is set as $L / d \pi \geq 1.5$.

Claim 12 (Withdrawn): A cylindrical metal member to be cast-wrapped as claimed in claim 6 or 7, wherein said metal member to be cast-wrapped is a hollow cylindrical body.

Claim 13 (Withdrawn): A method for manufacturing a cylindrical metal member to be cast-wrapped as claimed in claim 9 or 10, wherein said metal member to be cast-wrapped is a hollow cylindrical body.

Claim 14 (currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 1, wherein said metal member is a cylindrical member that has an outer surface ~~containing~~ having at least one extruded upsets forming irregular surfaces defining roughened surface portion defined by said surface tears producing said irregularly formed projections extending outwardly from said surface, said projections of a roughened surface portion being provided in mutually adjoining disposition and, all of said projections being arranged axially of the cylindrical member in rows in a row extending parallel to an axis of the cylindrical member and at intervals spaced circumferentially about the cylindrical member.

Claim 15 (Previously presented): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein each of said projection-defining tears has a tip end portion bent laterally.

Claim 16 (Previously presented): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein unroughened grooves are provided between circumferentially adjacent rows of projection-defining tears.

Claim 17 (Currently amended): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein said roughened surface contains rows of projections ~~projection~~ defining ~~upsets are~~ tears, said rows being arranged at regular intervals ~~in said rows~~ about the circumference of said cylindrical member.

Claim 18 (Previously presented): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein said projection-defining tears are arranged at irregular intervals in said rows and generally out of circumferential alignment.

Claim 19 (Previously presented): A metal member to be cast-wrapped by a metal cast article as claimed in claim 14, wherein said cylindrical member is hollow.